

Date: Tuesday, 14/10/2008 1:21:23 PM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RING
Job Number : 42569	
Estimate Number : 12922	
P.O. Number :	Part Number : D2655
This Issue : 14/10/2008 S.O. No. :	Drawing Number : D2655 REV B-BLUE
Prsht Rev. : NC	Project Number : N/A
First Issue : 14/10/2008 Type : SMALL /MED FAB	Drawing Revision :
Previous Run : 34595	Material :
Written By :	Due Date : 31/10/2008
Checked & Approved By : <u>JLD 08.10.14</u>	Qty: 8 Um: Each
Comment : Est Rev:A New Issue 07-07-04 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1018B400X250	1018 bar 4.00 x .250
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m1018B 400x0250



Comment: Qty.: 0.2835 f(s)/Unit Total : 2.2680 f(s)
1018 ASTM A36 .250" thk bar x 4.0"
Batch: 109744 B 8-11-3

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D2655
Dwg Rev: B
Prog Rev: B

B 8-11-3



2-Deburr if necessary B 8-11-3

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B 8-11-3



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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08-11-03 10



Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Tumble - .030 Radius
2-Deburr any rough edges after tumbling

08/11/06 10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 14/10/2008 1:21:23 PM
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Process Sheet

MATT-ASAP

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RING

Job Number: 42569

Part Number: D2655

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/11/06 (xrs)

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

-PRIME

B109083

-PAINT DELFLEET BLUE

B105918

-CLEAR DELFLEET

B109816

ml 08 11 10 (10)

8.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

28 08 11-11

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

P. G. P. P.

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/12

Job Completion



unf 08-11-11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

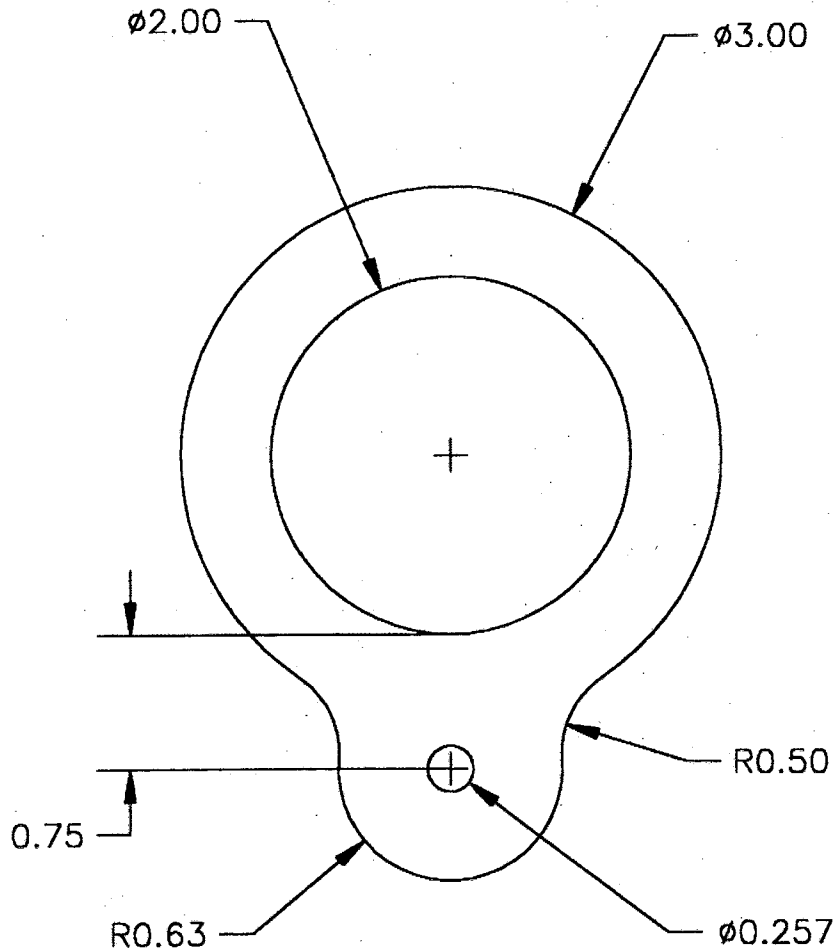
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2655	REV. B SHEET 1 OF 1
DATE 97:07:07		TITLE RING	SCALE 1:1
A	97:03:25	NEW ISSUE	
B	97:07:07	ADD ASTM A36 TO MAT. SPEC.	

RELEASED
47/07/11 DS



NOTE: DEBURR ALL SHARP EDGES
MATERIAL: AISI 1018/1020/1025 OR ASTM A36 0.250 THICK
FINISH: POWDER COAT PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
NO. 4258